

Claims

1. Method for producing a cup-shaped annular part (2') having an inner toothing (6), whereby a cup-shaped preform having an annular element (3) and a hub part is arranged in a matrix part, whereby a punch part that an outer toothing has on its outer wall that corresponds to the inner toothing (6) that is to be produced in the annular element (3) is inserted into the interior space of the preform and whereby a pressure is exerted in a forming step on the front surface of the open end of the preform by carrying out a relative movement between the matrix part and the punch part with the aid of an annular punch part, characterized in that an annular groove is provided in the floor space of the hub part in the corner region between the inner surface of the annular element (3) and the floor space of the hub part so that material of the preform flows across the punch part into the region of the groove when exerting pressure on the front surface of the open end of the preform.
2. Method, particularly pursuant to claim 1, characterized in that, the groove is inserted into the preform in such a way that its radially outer side is an extension of the inner surface of the annular element (3) of the preform.
3. Method, particularly pursuant to claim 1 or 2, characterized in that an outer toothing is produced on the outer side of the annular part (2') in the same forming step in that the matrix part has an inner toothing on its inner surface that corresponds to the outer toothing.
4. Method, particularly pursuant to any of the claims 1 to 3, characterized in that, for producing an annular part (2') having an axle pin, a matrix part is used that has a central recess for accommodating the axle pin.

5. Method, particularly pursuant to any of the claims 1 to 3, characterized in that, for producing an annular part having a central borehole in the hub part, a preform is used that has a central borehole in the hub part.

6. Method, pursuant to any of the claims 1 to 5, characterized in that, a drawing ring is used that surrounds the region of the annular element (3) of the preform that projects over the matrix part in order to exert a radial counterpressure during the forming process.

7. Method, particularly pursuant to claim 6, characterized in that, the drawing ring is provided with a single-piece design with the matrix part.

8. Cup-shaped preform, particularly for implementing a method pursuant to any of the claims 1 to 7, characterized in that it has an annular groove in the end region between the annular element (3) and the floor space of the hub part.

9. Cup-shaped preform, particularly pursuant to claim 8, characterized in that the radially outer side of the groove forms an extension of the inner surface of the annular element (3).

10. Cup-shaped annular part, produced particularly according to a method pursuant to any of the claims 1 to 7 and/or produced particularly in a cup shape pursuant to claim 8 or 9, whereby the annular part comprises an annular element (3) having an inner toothing and a hub part, characterized in that the teeth of the inner toothing of the annular element (3) extend exactly up to the level of the floor space of the hub part.